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D4812-041
Job Sheet 196662



Part No: D4812-041

Job Qty: 6 pcs

DAS
21
9-59

Part Name: Patient Stop Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/18/19

Job Tracking No:

Due Date: 7/12/19

DAS
21
9-59

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV B IPP REV:A 13.05.21 AS PER DWG REV.A VERF:JLM IPP REV:B 16.04.19 AS PER DWG REV.B VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	8 pcs		7/12/19	0.17	2.12	Waterjet - Flow	9/15/19	JRB
110	QC 2	8 pcs		7/12/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

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Container No: S213778

Part: D4812 - 041

Job No: 196662

Serial No/Batch: S213778

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 09/15/19

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120 QC 8	8 pcs	7/12/19	0.00 0.00	QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	JRB
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	DAS
				QC 8 - 47	40
				QC 8 - 40	SEP 16 2019 9-38
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
130 Small Fab - 2 - B4B	8 pcs	7/12/19	0.08 2.13	Small Fab - 1 - B4B	
				Small Fab - 2 - B4B	DAS
				Small Fab - 3 - B4B	30
				Small Fab - 4 - B4B	SEP 20 2019 9-89
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
140 QC 5	8 pcs	7/12/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	SEP 26 2019 DAS
				QC 5 - 30	SEP 26 2019 40
				QC 5 - 40	SEP 26 2019 9-89
150 Handfinish - 1-1 Chemical-B4B	8 pcs	7/12/19	0.00 0.93	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	SEP 30 2019
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	

						Handfinish - 1 - 6 - B4B							
						Handfinish - 1 - 7 - B4B							
						Handfinish - 1 - 8 - B4B							
						Handfinish - 1 - 9 - B4B							
						Handfinish - 1 - 10 - B4B							
						Handfinish - 1 - 11 - B4B							
						Handfinish - 1 - 12 - B4B							
						Handfinish - 1 - 13 - B4B							
						Handfinish - 1 - 14 - B4B							
						Handfinish - 1 - 15 - B4B							
						Handfinish - 1 - 16 - B4B							
						Handfinish - 1 - 17 - B4B							
						Handfinish - 1 - 18 - B4B							
						Handfinish - 1 - 19 - B4B							
						Handfinish - 1 - 20 - B4B							
						Handfinish - 1 - 21 - B4B							
						Handfinish - 1 - 22 - B4B							
						160 QC 7	8 pcs	7/12/19	0.00	0.00		QC 7 - 10	
												QC 7 - 13	
												QC 7 - 14	
												QC 7 - 15	
												QC 7 - 17	
QC 7 - 18													
QC 7 - 19													
QC 7 - 2													
QC 7 - 28													
QC 7 - 3													
QC 7 - 30													
QC 7 - 34													
QC 7 - 36													
QC 7 - 37													
QC 7 - 41													
QC 7 - 47													
QC 7 - 48													
QC 7 - 51													
QC 7 - 58													
QC 7 - 59													
QC 7 - 60													
QC 7 - 9													
QC 7 - 68													
QC 7 - 50													
QC 7 - 67													
QC 7 - 40													
QC 7 - 24													
QC 7 - 43													
170 Powdercoat - 1 White Gl(A)- B4B	8 pcs	7/12/19	0.00	0.67		Powdercoat - 1 - B4B							
						Powdercoat - 2 - B4B							
						Powdercoat - 3 - B4B							
START: 11:05 O.V.T. 30° Finish: 11:35													
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6/18/2019

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

				Powdercoat - 4 - B4B	
180 QC 3	8 pcs	7/12/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	DAS 58 SEP 30 2019
				QC 3 - 59	9-89
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	DAS 58 SEP 30 2019
190 Small Fab - 3 - B4B	8 pcs	7/12/19	0.00 2.13	Small Fab - 1 - B4B	DAS 58
				Small Fab - 2 - B4B	9-89
				Small Fab - 3 - B4B	
				Small Fab - 4 - B4B	
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
200 QC 5	8 pcs	7/12/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	DAS 81
				QC 5 - 43	9-89
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
210 Packaging 3-1 - Stock - B4B	8 pcs	7/12/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	

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					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
					QC 21 - SA - 21	
					QC 21 - SA - 70	
					QC 21 - SA - 53	
220 QC 21 - SA	8 pcs	7/12/19	0.00	0.00		

PC. ST208

DAS
21
3-09 OCT 04 2019

Part Op 110 - (QC2- Inspect parts off machine FAI/FAIB)
 Descriptions: 120 - (QC8- Inspect parts - second check)
 130 - (Small Fab)
 140 - (QC5- Inspect part completeness to step on W/O)
 150 - (Chemical Conversion Coat per QSI005 4.1)
 160 - (QC7-Inspect Chemical Conversion Coat)
 170 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum)
 180 - (QC3- Inspect Part Finish)
 190 - (Small Fab)
 200 - (QC5- Inspect part completeness to step on W/O)
 210 - (Identify as per dwg & Stock Location: _____)
 220 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.063	6061-T6 .063 Sheet	16.2400 sf (2.03 ea)	100-Waterjet - Flow - 1	5190194
D2690-6	Lanyard	16 pcs (2 ea)	190-Small Fab - 3 - B4B	5197091 x 8
D4811-1	Pin, Quick Release	16 pcs (2 ea)	190-Small Fab - 3 - B4B	5170513 x 4
MS21042L3	Nut	16 Ea (2 ea)	190-Small Fab - 3 - B4B	5209283
MS27039-1-07	Screw	16 Ea (2 ea)	190-Small Fab - 3 - B4B	5193498
NAS1149D0332J	Washer	48 Ea (6 ea)	190-Small Fab - 3 - B4B	5209100

ST009
GAB2
ST303
ST281
ST2845197091 x 8
5170513 x 4
5209283
5193498
5209100
51108

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M6061T6S.063	16	554	0
190-Small Fab - 3 - B4B	D2690-6	16	132	0
	D4811-1	16	22	0
	MS21042L3	16	1,419	0
	MS27039-1-07	16	80	0
	NAS1149D0332J	48	3,102	0

Part Specifications

Specifications could not be found.

INSPECTION SHEET

Rev	Date	Change	Revised by	Approved
A	15.04.27	New Issue	KJ	
B	16.06.24	Dwg Rev updated	KJ	



Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only

NCR No. _____

Job: _____

Part No. _____

DISPOSITION

Rework ☐ ☐ ☐
Scrap ☐ ☐ ☐
Use-as-is ☐ ☐ ☐

DEPARTMENT/PROCESS

Cross tube ☐ ☐ ☐
Small Fab ☐ ☐ ☐
Finishing ☐ ☐ ☐

Eng. (Non-AW) ☐ ☐ ☐
Prod. Eng. Coord. ☐ ☐ ☐
Rec/Store/Packaging ☐ ☐ ☐

Skid-tube ☐ ☐ ☐
Machining ☐ ☐ ☐
Large Fab ☐ ☐ ☐

Engineering ☐ ☐ ☐
Water Jet ☐ ☐ ☐
Supplier ☐ ☐ ☐
Quality ☐ ☐ ☐

MRB (QS1042)

Date: _____ Sequence #: _____

QTY Affected: _____

Description Work Order Deviation

Disposition

Completed By _____

Lead hand / Supervisor _____

QC / QA Coordinator _____

Root Cause

Operator ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐
Manufacturing Process ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐
Equip/Tooling ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐
Handling/Preservation ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐
Material ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐
Product Improvement ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐
Process Improvement ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐
Human Factors ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐

FAULT CATEGORY

Pressure/Forced ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐
Bending ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐
Crushing ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐
Cracks ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐
Crimp/kink/Ripple/Wave/Twist ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐
Marks/Chatter ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐
Mislabeled ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐
Other/Details: _____

Contamination ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐
Misaligned/off center ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐
BOM/Route ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐
Broken/Damage/Defect ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐
Incomplete/Unclear Instructions ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐
Drill Holes ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐
Fit/Function ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐

Power Loss/Surge ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐
Folio/Program ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐
Grain Direction ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐
Weld ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐
Wrong Stock Pulled ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐
Out of Sequence ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐
Off-set/Set-up ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐

Positioned Wrong ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐
Outside Tolerance ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐
Drawing ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐
Finish ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐
Part Lost/Missing ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐
Misread ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐